

# Work Order ID 87023

Monday, July 09, 2012 9:14:52 PM

**\*87023\***

Page 1

Item ID: D4522-049

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Base, Latch Shaft

Start Date: 7/10/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4522

B

100

0.00

**\*100\***

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK AT 1.750"

110

0.00

**\*110\***

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER DWG & FOLIO FB103

FOLIO REV:

DWG REV:

DEBURR

INSERT Helicorl.  
AS PER DWG

12.07.16

**\*87023\***

Monday, July 09, 2012 9:14:52 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 7/10/2012      **Start Qty:** 2.00      **\*2\***

**Required Date:** 7/19/2012      **Req'd Qty:** 2.00      **\*?\***

**Customer:**

Run Start \*NR1\*

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

120	<b>QC2- Inspect parts off machine FAI/FAIB</b>	0.00			
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**\*120\***

QC Memo

## Quality Control

130	QC8- Inspect parts - second check	0.00
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\*130\*

QC Memo

## Quality Control

160 Identify as per dwg & Stock Location: 217 0.00

**\*160\***

Packaging	Memo
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### Packaging

Page 3

### Quality Control

12/17/23

MF  
12-07-1-

# Picklist Print

Monday, July 09, 2012 9:14:52 PM

Page 1

Work Order ID: 87023

Parent Item: D4522-049

Parent Item Name: Base, Latch Shaft

Start Date: 7/10/2012

Required Date: 7/19/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-02-18 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6B2.000X02.000  
6061-T6 Bar 2.00 x 2.00

Purchased

No

f 12.2570

0.29

B.A 12/07/10

Location

Loc Qty

Loc Code

MAT009

12.257

→ 113123

1.977

119801

9.09

13085

1.19

0.3016 ft

MS21209-C0820

Purchased

No

Each 10.0000

2

Threaded Insert, 8-32 UNC x 0.33 LG

Location

Loc Qty

Loc Code

ST305

10

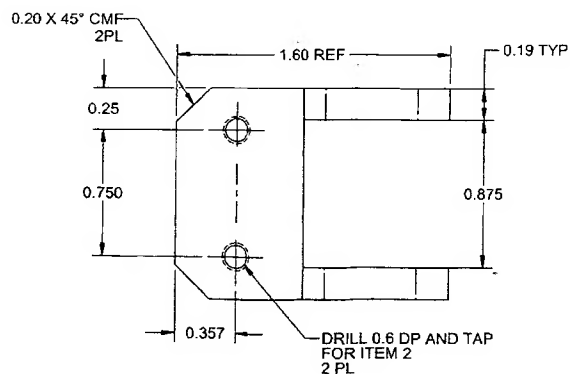
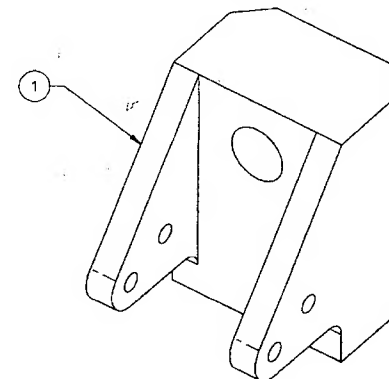
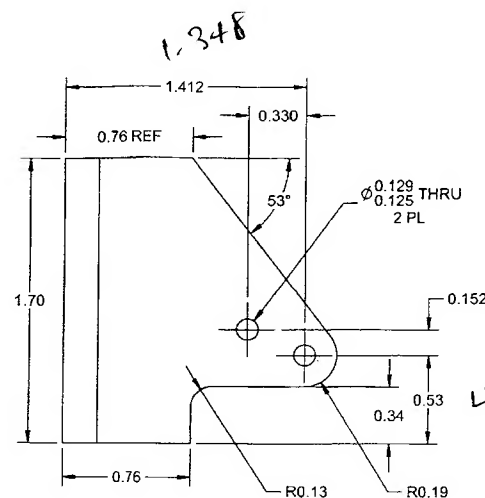
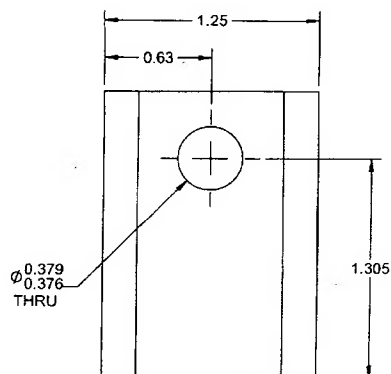
120593 ✓

10

x 2

2 12-7-15




ITEM	QTY	P/N	DESCRIPTION
	X	D4522-049	BASE, LATCH SHAFT
1	1	D4522-7	BASE, LATCH SHAFT
2	2	MS21209-C0820	THREADED INSERT, 8-32 UNC X 0.33 LG



# NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR  
AMS4117/4128/4115/4116 OR QQ-A-200/8 OR  
AMS 4160 OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.16 lbs

**D4522-049 BASE, LATCH SHAFT**

DESIGN	RP	<b>DART AEROSPACE LTD</b>	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.		D4522	SHEET 11 OF 23
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
DATE	12.04.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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**RELEASED**  
2012-06-13

0875

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD.</b>		<b>Work Order:</b> 87023
<b>Description:</b> LATCH SHAFT		<b>Part Number:</b> 4522-019
<b>Inspection Dwg:</b>	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/- .030	1.250	/		29.02	
.63	+/- .030	.626	/			
.379	+/- .030	.376	/			
1.412	+/- .010	1.419	/			
.76 REF	+/- .030	.761	/			
.330	+/- .010	.331	/			
53°	+/- 1/2°	53°	/			
1.70	+/- .030	1.699	/			
.129 REF	+/- .030	.125	/			
.152	+/- .010	.152	/			
.53	+/- .030	.525	/			
.34	+/- .030	.339	/			
.76	+/- .030	.762	/			
R. 13	+/- .030	.125	/			
R. 19	+/- .030	.190	/			
.20x.45	+/- .030	.20	/			
1.60 REF	+/- .030	1.605	/			
.19 REF	+/- .030	.186	/			
.25	+/- .030	.250	/			
.750	+/- .010	.750	/			
.357	+/- .010	.358	/			
.875	+/- .010	.877	/			
.6 REF	+/- .060	.602	/			

<b>Measured by:</b> 29	<b>Audited by:</b> DAS 14	<b>Preliminary Approval:</b>
<b>Date:</b> 12-7-15	<b>Date:</b> 12/08/16	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15